

Date: Friday, 25/07/2008 4:20:57 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	40766		
Estimate Number :	13514		
P.O. Number :		Part Number :	D21971
This Issue :	25/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2197 REV C
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	C
	Type :	Material :	
	SMALL /MED FAB	Due Date :	20/08/2008
Written By :		Qty:	2
Checked & Approved By :	JUD 08.7.25	Um:	Each
Comment :	Est Rev:A / 08-07-24 new issue ec verified by:dd		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.1457 sf(s)/Unit Total : 0.2915 sf(s)

304 SS Sheet 0.063" thick

batch: 108724 IB 8-8-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2196

Dwg Rev: C

Prog Rev: C

IB 8-8-20

③

2-Deburr if necessary

IB 8-8-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-8-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/08/20

③

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per dwg D2196

SB 09/08/25

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:57 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40766

Part Number: D21971

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/05 (+3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: 19

8/8/05

(3X)

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26 fj

Job Completion



u 08-08-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

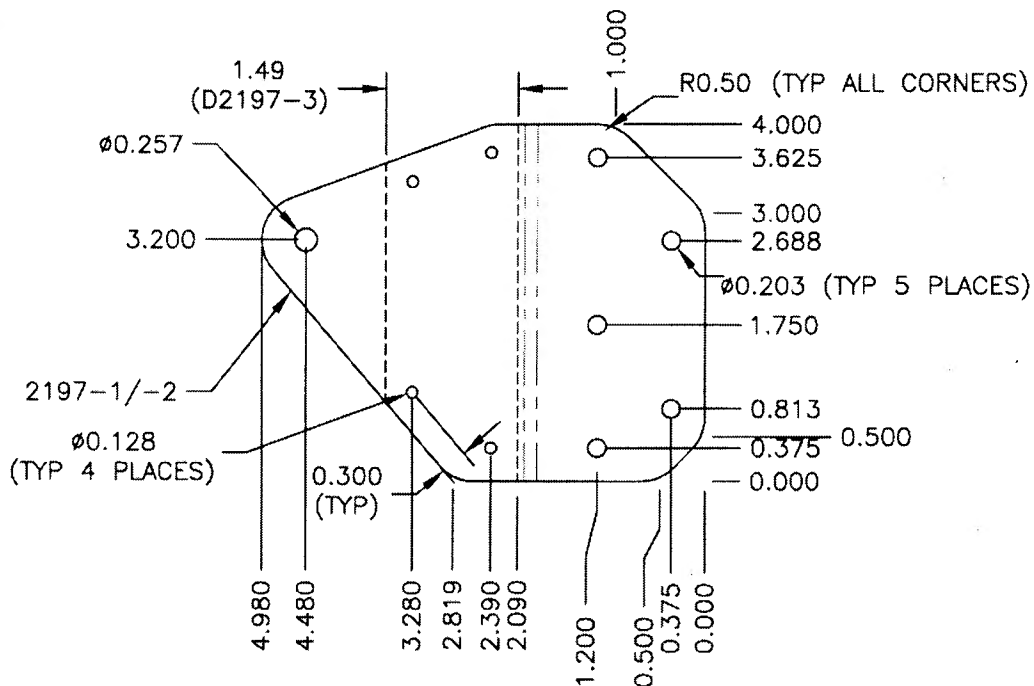
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2197	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2197-3 NOW 0.5" THICK	

D2197-1/-2/-3
FLAT PATTERN



D2197-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2197-3

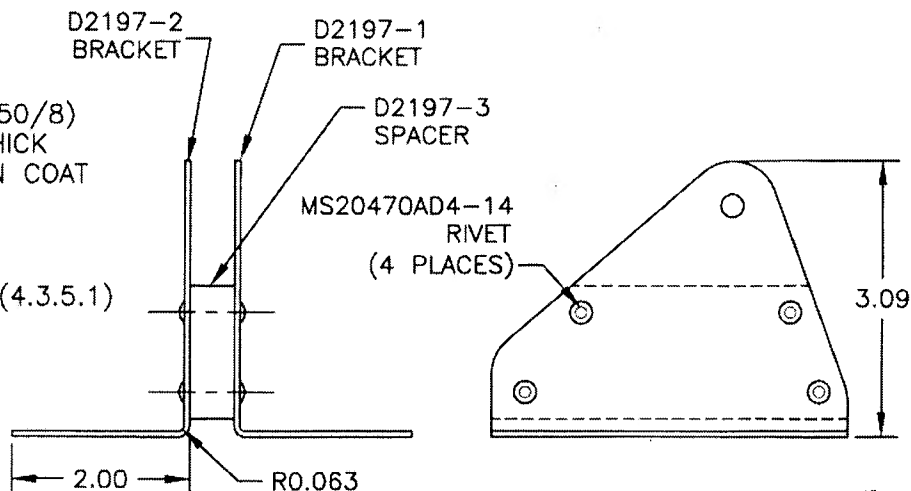
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2197 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2197 BRACKET
(ASSEMBLY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84872

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DART AEROSPACE LTD		Work Order: 40766
Description: BRACKET		Part Number: 02197-1
Inspection Dwg: D2197-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.128	+ .005 - .001	.131	*			
.203	+ .005 - .001	.207	*			
.257	+ .006 - .001	.261	*			
.300	+/- .010	.298	*			
.375	+/- .010	.373	*			
.500	+/- .010	.500	*			
1.200	+/- .010	1.201	*			
2.390	+/- .010	2.390	*			
3.280	+/- .010	3.283	*			
4.480	+/- .010	4.480	*			
4.980	+/- .010	4.983	X			
.500	+/- .010	.500	X			
.813	+/- .010	.813	*			
1.750	+/- .010	1.752	*			
2.688	+/- .010	2.690	*			
3.625	+/- .010	3.626	X			
4.000	+/- .010	4.004	*			
.063	+/- .010	.060	X			

Measured by: RB	Audited by: S	Prototype Approval: N
Date: 8-8-20	Date: 08/08/20	Date: A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	